

Work Order ID 64281

December 1, 2010 1:00:11 PM



Page 1

Item ID: D3569-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Decal

Start Date: 12/01/10 Start Qty: 20.00



Cust Item ID:

Required Date: 12/08/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 10/12/10 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3569

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13045 ☐ Manufacture as per Dwg D3569 using 3M 7mil masking film #8522cp or Avery IPM #2031. ☐ Possible Supplier: Studio Lettrage ☐ Material release note is required

3/10-12-1
20

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure material release note is attached

CL 10/12/10 (20)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

8/10/12/10

count
x20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64281

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December 1, 2010 1:00:11 PM

Item ID: D3569-3

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Setup Start



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Item Name: Decal

Start Date: 12/01/10 Start Qty: 20.00



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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>245A</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/12/17 SL 260

10/12/08

CMF

10-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 1, 2010 1:00:10 PM

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Work Order ID: 64281



Parent Item: D3569-3



Parent Item Name: Decal


Start Date: 12/01/10

Required Date: 12/08/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-04-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3569-3P  LABEL		Purchased	No				Each	0.0000	1	20			



Signature *6/2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

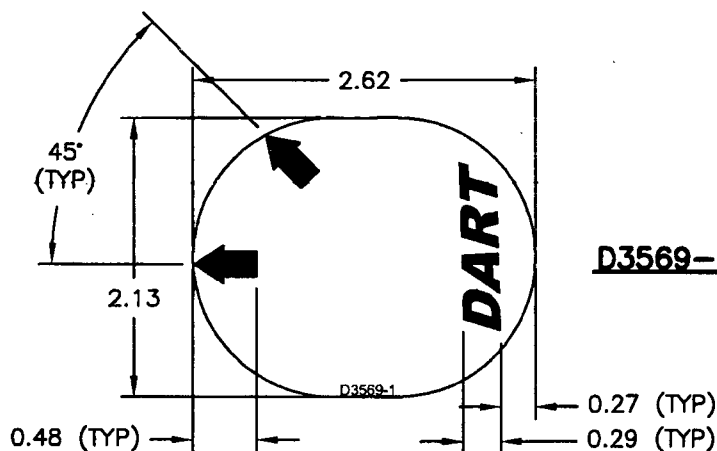
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



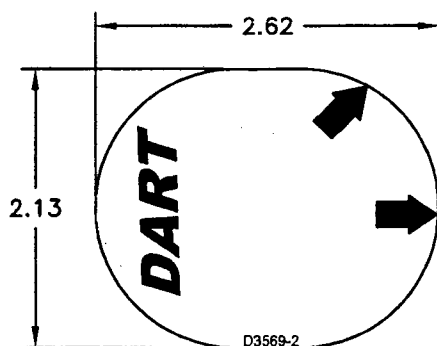
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3569	REV. A SHEET 1 OF 1
DATE 07.01.25		TITLE DECAL	SCALE NTS
A	07.01.25	NEW ISSUE	



D3569-1 DECAL

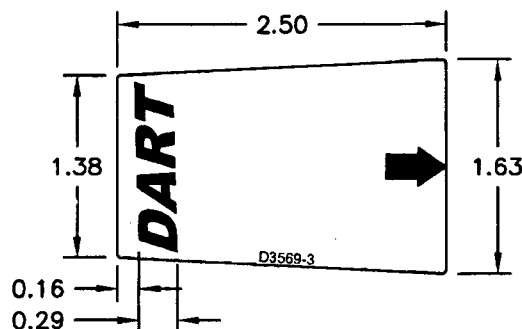
RELEASED

07.04.12



D3569-2 DECAL

cd10112101
w10:64281



D3569-3 DECAL

NOTES:

- 1) MATERIAL: BLACK PRINT WITH FLUORESCENT GREEN ADHESIVE BACK
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13045

Purchase Order Date 12/1/2010

PO Print Date 12/1/2010

Page Number 1 of 1

Order From :

VC-STU001

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

Contact Name

Vendor Phone

613 632 5449

Vendor Fax

613 632 9491

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2258-200P	Weight Placard 200lb	12/8/2010 Yes	12.00 Each	Yours ppd	\$7.5000	\$90.00
		Special Inst:	AS PER DWG D2258 REV: D BATCH# 64284				
2	D3569-3P	LABEL	12/8/2010 Yes	20.00 Each	Yours ppd	\$3.3333	\$66.67
		Special Inst:	AS PER DWG D3569 REV: A BATCH#64281				
3	D3605-1P	PLACARD	12/8/2010 Yes	8.00 Each	Yours ppd	\$6.0000	\$48.00
		Special Inst:	AS PER DWG:D3605 REV: A BATCH# 64286				

PO Total:

\$204.67

Change Nbr: 2

Change Date: 12/1/2010

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 14966
Date: 12/06/2010
Ship Date:
Page: 1
Re: Order No. 9987

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

Business No.: 869034678RP0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		12	D2258-200P-set up	H		50.00
		20	D3569 -3P set up	H	2.50	50.00
		8	D3605-1P set up	H	6.25	50.00
		1	printing	H	75.00	75.00
			H - HST 13%			
			HST			29.25
			PST Exempt: #6122-5207			
Studio de Lettrage HST: #869034678RP001						
Shipped By: Tracking Number:						
Comment: PO 13045						
Sold By:						
Total Amount						254.25



Avery Graphics™ A5 Opaque
5-year INTERMEDIATE calendered vinyl film
Dated: 10/3/02

Description: Avery Graphics™ A5 Opaque intermediate films are flexible, high-gloss calendered vinyls designed for use on computer sign cutting equipment. This construction provides excellent cutting, weeding and transferring characteristics for signage applications.

Application information can be found in the Avery Graphics Application Guide.

For surface preparation, converting and printing, and application and removal instructions, please refer to the Avery Graphics Instructional Bulletin.

Construction:

- Face Film: 3.2 mils opaque medium gloss intermediate calendared vinyl film
- Adhesive: 1.0 mil clear acrylic permanent solvent pressure-sensitive adhesive
- Liner: 78# bleached white kraft

Physical Properties:
The following information on physical and chemical characteristics is based upon tests believed to be reliable. The values are intended only as a source of information. They are given without guarantee and do not constitute a warranty. The purchaser should independently determine, prior to use, the suitability of this material for his/her specific purpose. (Data represents averages and is not intended for use as a specification).

- Outdoor durability: 5 years when properly processed and applied (vertical exposure, unprinted film)**
- Application surface contours: Flat and simple curves
- Minimum surface and air application temperature: +50° F (10° C)
- Service Temperature Range: -40° F to +180° F (-40° C to 82° C) (Reasonable range of temperatures which would be expected under normal environmental time and temperature conditions)
- Typical Chemical Resistance: Resistant to most mild acids, alkalis and salt solutions. See instructional bulletin for recommendations on cleaning.
- Shelf Life: One year when stored at the following temperatures and humidity conditions: 68°-77° F (20° - 25° C) and 50±5% R. H.
- Typical Adhesion Values: **180° Peels**

Substrate	24 hrs	1 week
Stainless Steel	4.4 lbs/in	5.1 lbs/in
Glass	4.7 lbs/in	5.3 lbs/in

Glass 4.7 lbs/in 3.3 lbs/in

NOTE: Tested per ASTM D 1000. Always pre-test your specific substrate prior to actual application.

- Reflectivity: NA
- Typical Gloss*: 70 at 60°

- Tensile at Yield: 9.0 lbs/in to 15.0 lbs/in width
- Elongation: 100% minimum
- Dimensional Stability: Less than 0.03 in. (0.762mm). Shrinkage is determined by measuring shrinkage of unprinted film applied to to 36 in.² (91 cm²) aluminum test panel after 72 hrs. aging at 73° F (23° C) 50±5% R.H. followed by 48 hrs. at 150° F (65° C).

Typical Converting Methods:

CUTTING

Computer Sign Cutting: yes
Angle of Blade: 30° or 45°
Minimum letter Height: 0.5 inch

PRINTING

Thermal Transfer Printing: yes
Ink Jet Printing: no
E-Stat printing: no
Screen Printing: no

Exceptions:

Durability Exceptions: Colors with reduced durabilities are as follows: A5077-O Silver and A5247-O Gold are 3-year durable and A5003-O Clear is 4-year durable.

Gloss Exceptions: A5077-O Silver, A5247-O Gold and A5508-O Vibrant Blue have a typical gloss of 50 at 60°.

Pigmented Adhesive Exceptions: none

** Some color fade may occur in severe environmental areas such as, Florida, Arizona, Nevada, New Mexico, Utah, Southwest Texas and Southern California. Durability statement does not apply outside of the contiguous 48 states as testing has not been done in those regions.

WARRANTY: All statements, technical information and recommendations about Avery Dennison products are based upon tests believed to be reliable but do not constitute a guarantee or warranty. All Avery Dennison products are sold with the understanding that Purchaser has independently determined the suitability of such products for its purposes. Avery Dennison products are warranted to be free from defects in material and workmanship for either one year (or the period stated on the specific product information literature in effect at time of delivery, if longer) from date of shipment if said product is properly stored and applied. It is expressly agreed and understood that Avery Dennison's sole obligation and Purchaser's exclusive remedy under this warranty, under any other warranty, express or implied, or otherwise, shall be limited to repair or replacement of defective product without charge at Avery Dennison's plant or at the location of product (at Avery Dennison's election), or in the event replacement or repairs is not commercially practical, to Avery Dennison's issuing Purchaser a credit reasonable in light of the defect in the product.

Avery Dennison's liability for defective products shall not exceed the purchase price paid therefore by Purchaser and in no event shall Avery Dennison be responsible for any incidental or consequential damages whether foreseeable or not, caused by defects in such product, whether such damage occurs or is discovered before or after replacement or credit, and whether or not such damage is caused by Avery Dennison's negligence.

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